

Work Order ID 61402

August 24, 2010 9:01:01 AM



Page 1

Item ID: D212-580-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Cargo Mirror Assembly

Start Date: 8/24/10 Start Qty: 2.00



Cust Item ID:

Required Date: 9/07/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL

Date: 10/8/24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2161	Rev B2

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D212-580-041 CHG003

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Assemble on Jig DT8065 as per Dwg D2161 2-Weld as per Dwg

D2161 Identify as D2161-212 A/R SS ROD Batch: M108160

FL 10-8-30 (X2)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/24/10

(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00	B.E 10.08.30			2	φ		
140 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M 112588 Memo START TIME: 10:30 320° FINISH TIME: 11:00	0.00 0.00							
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	10/08/31			2	φ		

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/8/25 5120

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2 1005-01
- for E.D
- part placed in
Boxes.

180

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212--580-
041 ☐ Location: _____ ☐ PPP Rev: _____

10/8/25 12

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/02 *[Signature]*

mf

10-9-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 61402

Parent Item: D212-580-041

Parent Item Name: Cargo Mirror Assembly

Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:H Removed D2013-3/-4 06-03-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS27039-1-08

Purchased

No

100

Each

1,693.000

4

10/8/25

SP

Screw

Location

Loc Qty

Loc Code

ST291

1693

110835

493

114718

200

115108

1000

D2013-3

Manufactured

No

110

Each

2.0000

1

2

10/8/25

Mirror Bracket LH, 212

Location

Loc Qty

Loc Code

WA

2

60053

2

D2013-4

Manufactured

No

110

Each

2.0000

1

2

10/8/25

Mirror Bracket RH, 212

Location

Loc Qty

Loc Code

WA

2

60054

2

CCR264SS3-2

Purchased

No

170

Each

192.0000

4

18

10/8/25

Rivet, Cherry

Location

Loc Qty

Loc Code

ST311

192

106578

45

108738

47

112314

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 61402



Parent Item: D212-580-041



Parent Item Name: Cargo Mirror Assembly

Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 2.00

Required Qty: 2.00

D2011-103

Manufactured No

170

Each

30.0000

2

4



8" Mirror



10/8/25 SP

Location

Loc Qty

Loc Code

ST226

30

58399

30

D2037-101

Manufactured No

170

Each

6.0000

1

2



Arm



4
10/8/25 SP

Location

Loc Qty

Loc Code

WA

6

60059

6

MS21059L3

Purchased No

170

Each

42.0000

2

4



Nut Plate



2
10/8/25 SP 23

Location

Loc Qty

Loc Code

ST301

41

114718

41

ST302

1

114456

1

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

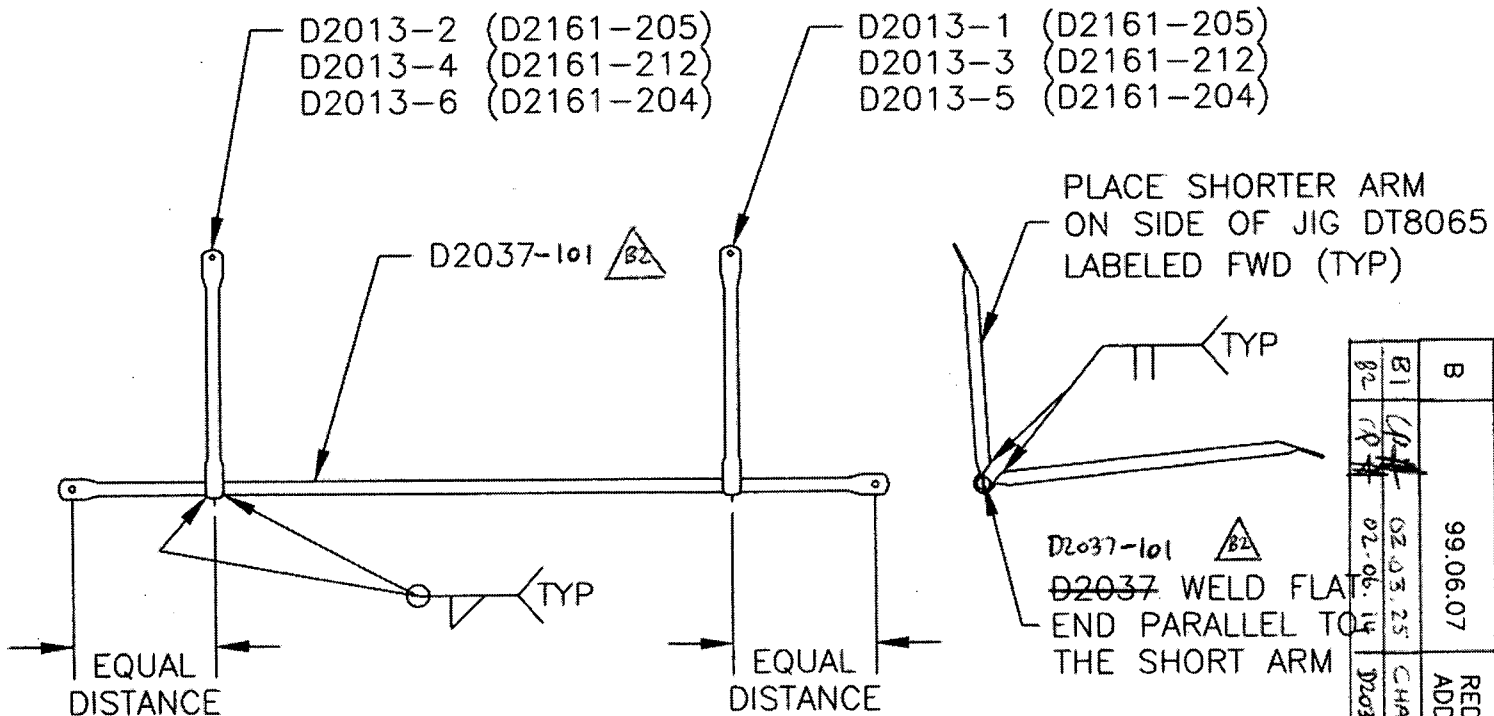
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ALL INFORMATION CONTAINED
HEREIN IS UNCLASSIFIED
DATE 08-22-2011 BY 60322
UCBAW/BJ

DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	DRAWN BY RT	REV. 8
CHECKED AE	APPROVED [Signature]	DRAWING NO. D2161 SHEET 1 OF 1
DATE 99.06.07	TITLE MIRROR BRACKET	SCALE NTS



DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
 POWDER COAT BLACK SANDTEX (4.3.5.7) PER
 DART QSI 005 4.3 B1

RELEASED
KE 99-06-10

REFERENCE ONLY

REFERENCE ONLY

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D204-562-041	5.0 lb	0 in	0 lb-in	3.80 in	19.0 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	0.10 m	0.23 m-kg
D205-563-041	5.0 lb	0 in	0 lb-in	3.80 in	19.0 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	0.10 m	0.23 m-kg
D212-580-041	5.0 lb	0 in	0 lb-in	-5.25 in	-26.3 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	-0.13 m	-0.30 m-kg

5.0 PARTS LIST

Qty 562 -041	Qty 563 -041	Qty 580 -041	Part Number	Description
X			D204-562-041	DUAL MIRROR INSTALLATION
	X		D205-563-041	DUAL MIRROR INSTALLATION
		X	D212-580-041	DUAL MIRROR INSTALLATION
2	2	2	D2011-103	MIRROR
1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	*2	*2	AN960JD516	WASHER
		4	CCR264SS-3-2	RIVET, BLIND
		2	MS21059L3	NUTPLATE
4	4	4	MS27039-1-08	SCREW

* PARTS ARE INCLUDED WITH D2011-103 MIRROR